

Work Order ID 155182

Monday, January 09, 2017 8:04:56 PM

155182

Page 1

** for flight Test **

Item ID: D5350-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Beam Assembly

Start Date: 01/09/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/13/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***QC: *[Signature]*

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5350	<i>Rev C</i>

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

Small Fab

Memo

0.04

Small Fab

ASSEMBLE AS PER DWG
SEE NOTE 9 FOR TORQUE SPEC ON NUTS*ix* *17/01/12* *DAS 36 9-89*

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control

(K1) *17/01/13* *DAS 16 9-89*
For Flight Test

130	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Packaging

Memo

0.00

Packaging

[Signature]

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Item ID: D5350-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** Fwd Beam Assembly**Start Date:** 01/09/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 01/13/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

Work Order ID 155181***155181***

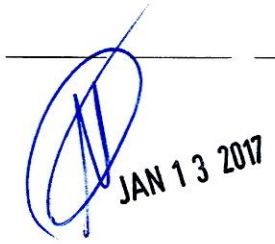
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Monday, January 09, 2017 8:03:12 PM

Item ID: D5350-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Beam Assembly
Start Date: 01/09/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 01/12/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									



JAN 13 2017

Picklist Print

Page 1

Monday, January 09, 2017 8:04:54 PM

Work Order ID: 155182

155182

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-11 *D2690-11* Lanyard Assembly		Manufactured	No				Each	0.0000		2			
									**	8155217	DAS 30 9-89	JAN 12 2017	
D3917-3 *D3917-3* Washer		Manufactured	No				Each	69.0000		2			
									**		DAS 30 9-89	JAN 12 2017	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST058				69					
				151081				16		2			
				152988				53					
D5205-1 *D5205-1* Bracket		Manufactured	No				Each	5.0000		1			
									**		DAS 30 9-89	JAN 12 2017	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST157				5					
				139876				1					
				148631				4		1			
D5346-3 *D5346-3* Bushing		Manufactured	No				Each	0.0000		4			
									**				
D5350-1 *D5350-1* Fwd Beam		Manufactured	No				Each	0.0000		1			
									**	8155096			

Picklist Print

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Work Order ID: 155182

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Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

D5350-5 Manufactured No

Each 0.0000

1

DAS
30
9-89

JAN 12 2017

D5350-5

Adapter

AN3-13A

Purchased No

Each 90.0000

2

DAS
30
9-89

JAN 12 2017

AN3-13A

Bolt

Location

Loc Qty

Loc Code

GA

16

m127070

16

ST349

74

153845

74

2

AN310-4

Purchased No

Each 103.0000

1

DAS
30
9-89

JAN 12 2017

AN310-4

Nut

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

40

M135704

0

M136295

40

ST331

38

M135704

3

M135999

35

1

AN4-20

Purchased No

Each 0.0000

1

DAS
30
9-89

JAN 12 2017

AN4-20

Bolt

M136573

①

Picklist Print

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Work Order ID: 155182

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Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C412

Purchased

No

Each

6.0000

2

MS17984-C412

**

Pin, Quick Release

Location

Loc Qty

Loc Code

ST315

6

m130358

1

m135297

5

MS21042L3

Purchased

No

Each

1,699.000

2

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

162

m134360

108

m135135

54

ST303

1437

M136044

337

M136192

600

M136406

500

MS24665-151

Purchased

No

Each

190.0000

1

MS24665-151

**

Cotter Pin

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

130

m135274

30

m136444

100

17/01/13
DAS
36
9-89

M136593 (2x)

DAS
30
9-89

JAN 12 2017

DAS
30
9-89

JAN 12 2017

Picklist Print

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Work Order ID: 155182

155182

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0316J

Purchased

No

Each

1,116.000

4

**

DAS
30
9-89

JAN 12 2017

NAS1149D0316.I

Washer

Location

Loc Qty

Loc Code

ST264

1116

M134502

1116

4

JAN 12 2017

NAS1149D0416J

Purchased

No

Each

3,949.000

2

**

DAS
30
9-89

NAS1149D0416.I

WASHER

Location

Loc Qty

Loc Code

GA

7

m131511

7

ST260a

2492

m131511

2492

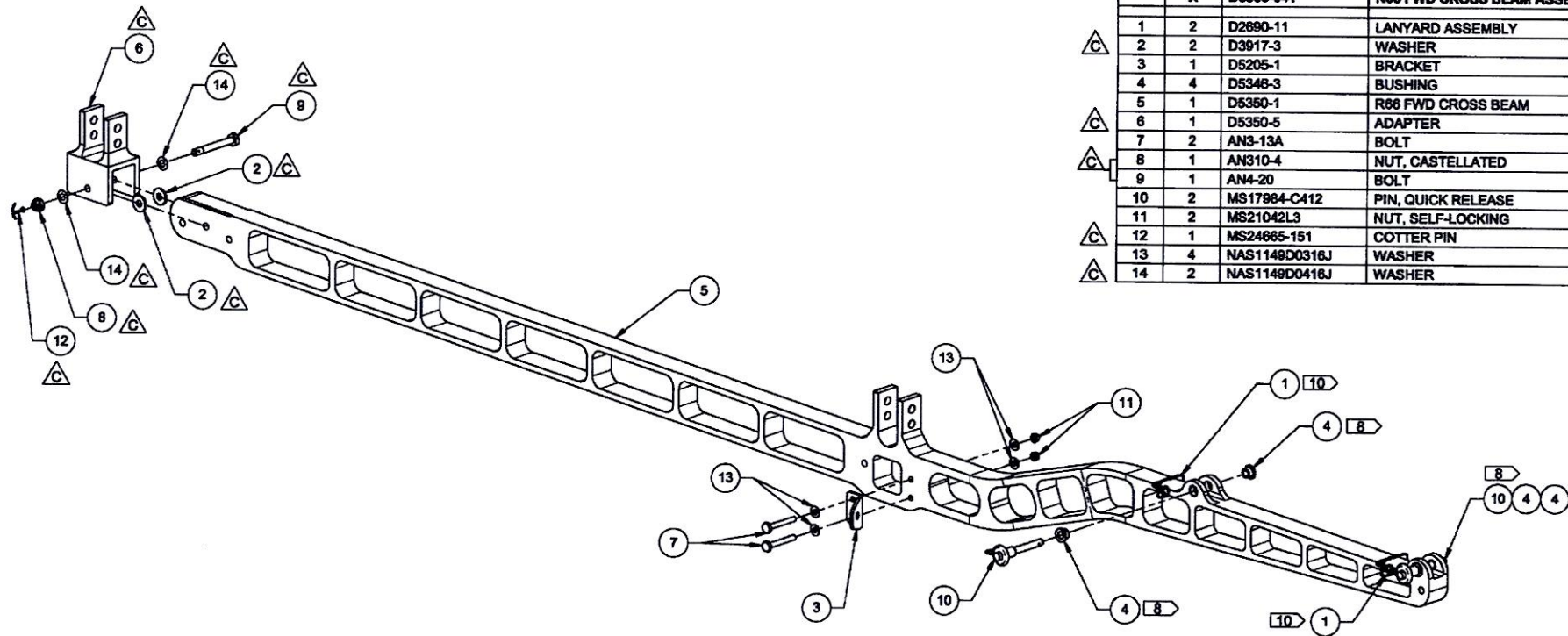
ST264

1450

m131511

1450

2



ITEM	QTY	P/N	DESCRIPTION
	X	D5350-041	R66 FWD CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	1	D5205-1	BRACKET
4	4	D5346-3	BUSHING
5	1	D5350-1	R66 FWD CROSS BEAM
6	1	D5350-5	ADAPTER
7	2	AN3-13A	BOLT
8	1	AN310-4	NUT, CASTELLATED
9	1	AN4-20	BOLT
10	2	MS17984-C412	PIN, QUICK RELEASE
11	2	MS21042L3	NUT, SELF-LOCKING
12	1	MS24665-151	COTTER PIN
13	4	NAS1149D0316J	WASHER
14	2	NAS1149D0416J	WASHER

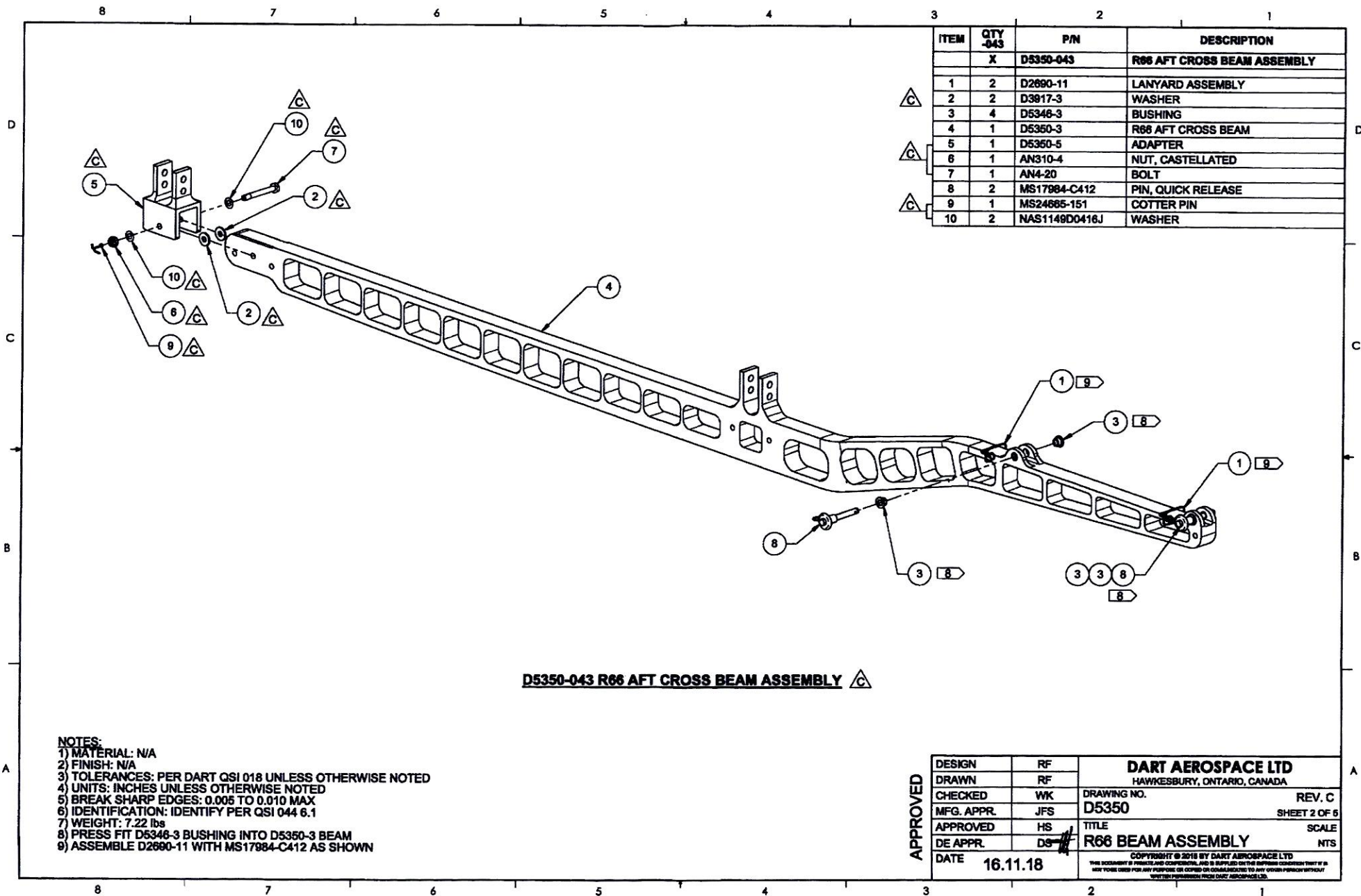
D5350-041 R66 FWD CROSS BEAM ASSEMBLY

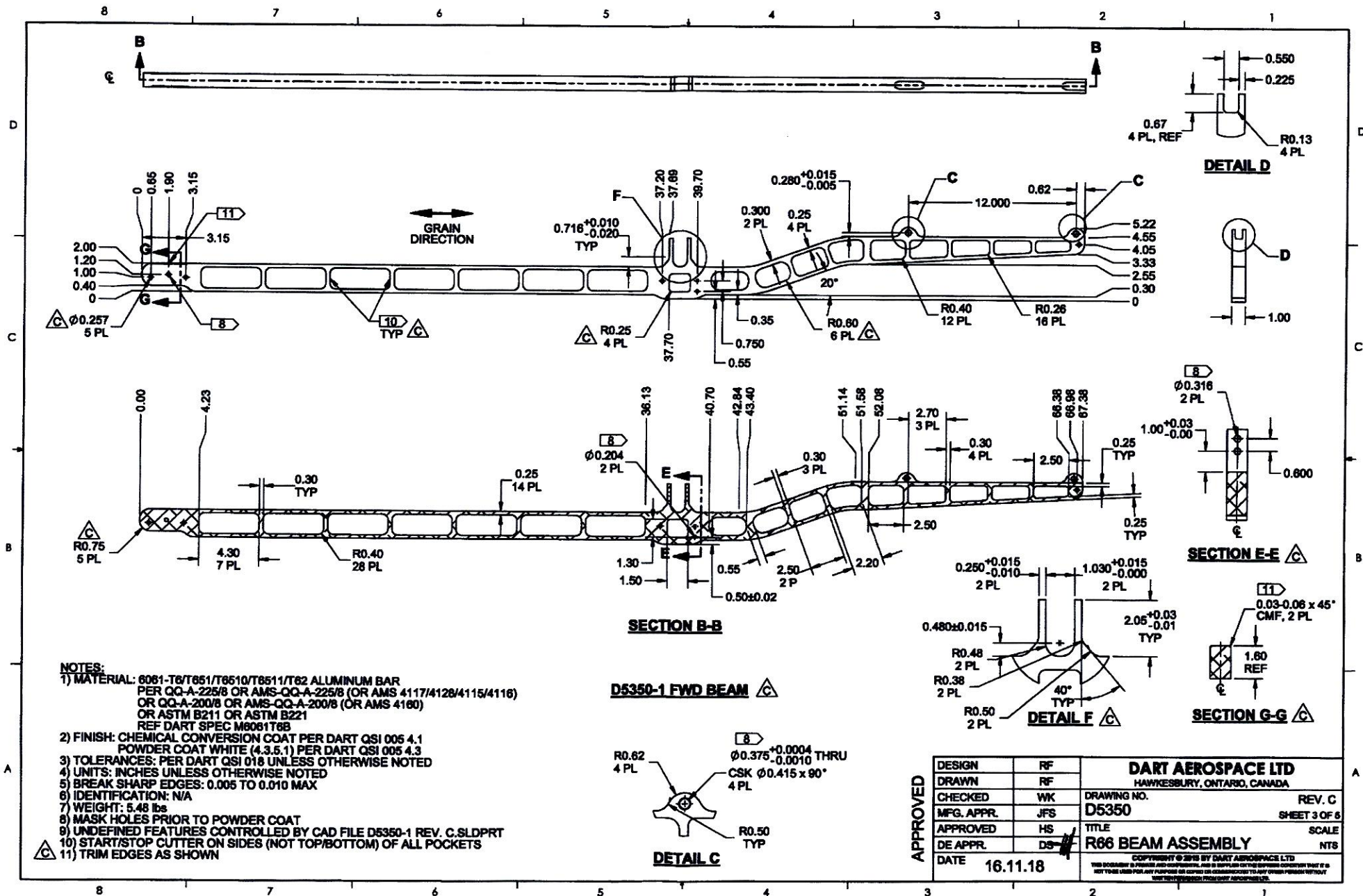
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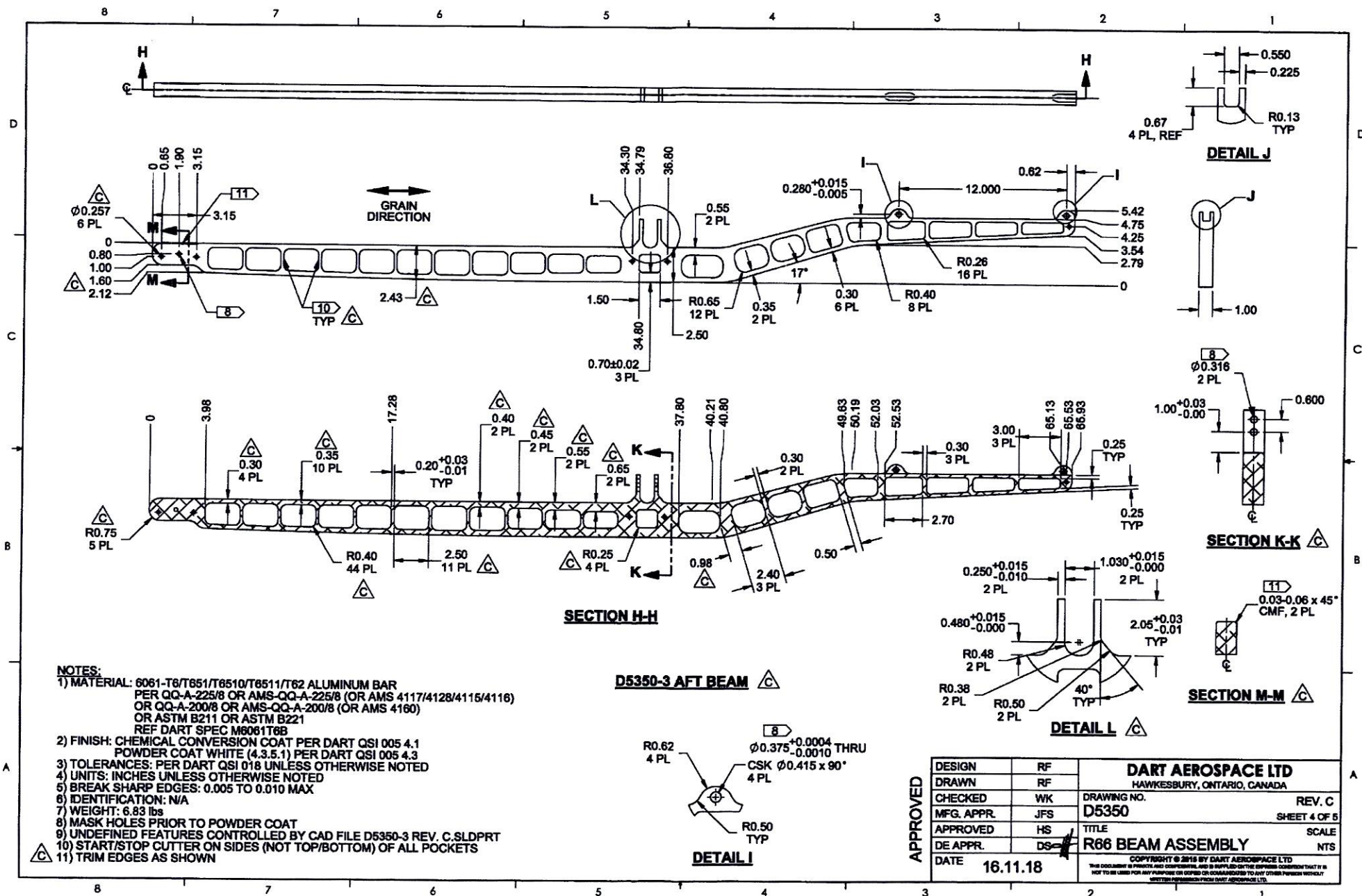
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.96 lbs
- 8) PRESS FIT D5346-3 INTO D5350-1
- 9) TORQUE MS21042L3 NUTS TO 20-25 in-lb (2.3-2.8 N-m)
- 10) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

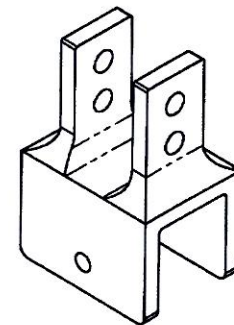
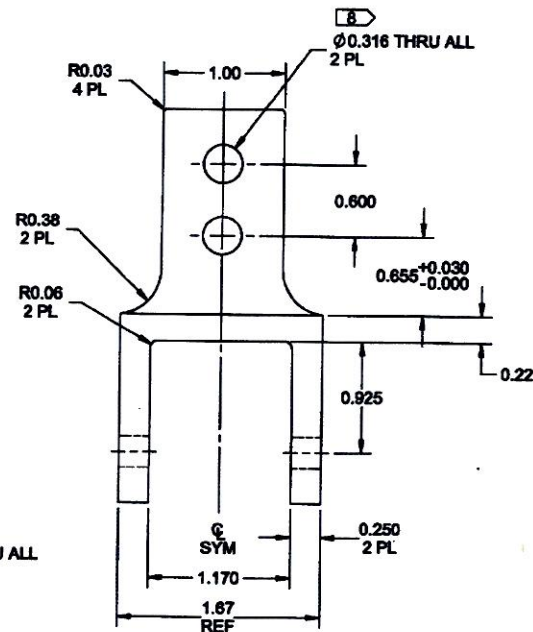
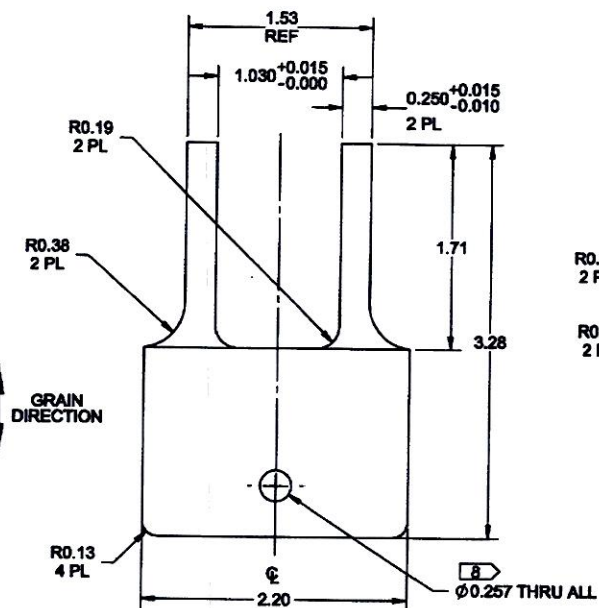
C	REDESIGN -1/3/0411-043 (ZN A4-1, A4-2, A4-3, A4-4); ADDED -5 (ZN A4-5) & NOTE 10 & 11 (ZN A5-3, A5-4); REVISE BOM's ZN (D3-1, D3-2)	RF	16.11.18
B	REDESIGN -1/3/0411-043 (ZN A4-1, A4-2, A4-3, A4-4)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5350	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
DATE	16.11.18	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

APPROVED









D5350-5 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/6 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/6 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5350	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
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